

Work Order ID 80506***80506***

Page 1

February-21-12 3:13:43 PM

Item ID: D4594-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/02/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4594

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

6061.030

Dwg Rev: AProg Rev: A

2-Deburr if necessary

W 12.02.27 (2)

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W 12.02.27 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

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NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
140	NC BRAKE	0.00							
140									
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

SB 2/26/12

SB 2/26/15

SB 2/26/15

② FF 12-03-12

②

②

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

2x Ø M / 12/03/15

170

~~QC3~~ Inspect Part Finish

0.00

170

QC

QC7

Memo

0.00

Quality Control

2x Ø M / 12/03/15 Pro

180

Identify as per dwg & Stock Location ST/394

0.00

180

Packaging

Memo

0.00

Packaging

2x SP 12-03-16.

Dart Aerospace Ltd

W/O: 80506		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/3/15	170	change to QC 7 Inspecti Level	QPS 12/03/19				S clocks

Part No: D4594-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12-03-14

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Picklist Print

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February-21-12 3:13:47 PM

Work Order ID: 80506

80506

Parent Item: D4594-1

D4594-1

Parent Item Name: Plate

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.23 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	212.3860	0.155	0.326316			

M6061T6S 032

**

W 12.02.27

6061-T6 Sheet 0.032"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	212.386	
118106	54.106	
120218	73.1	
120285	85.18	

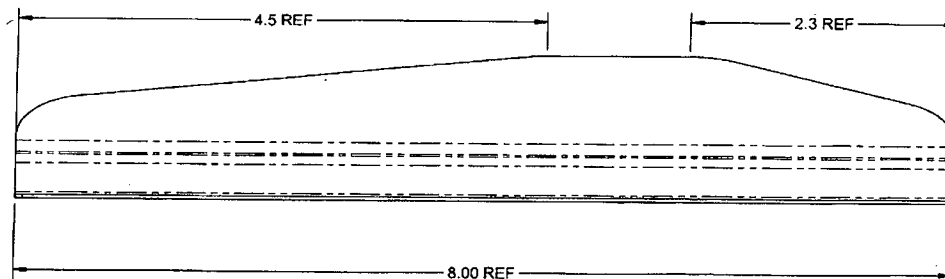
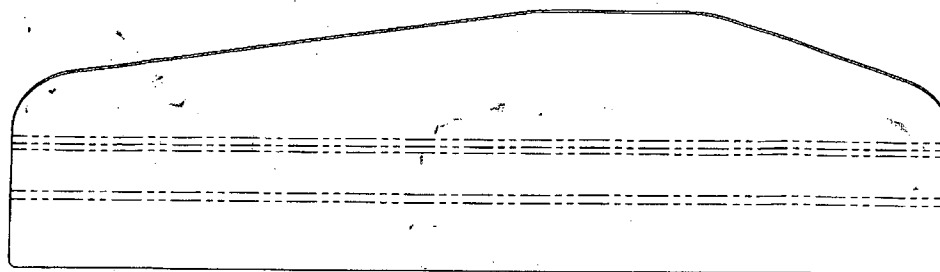
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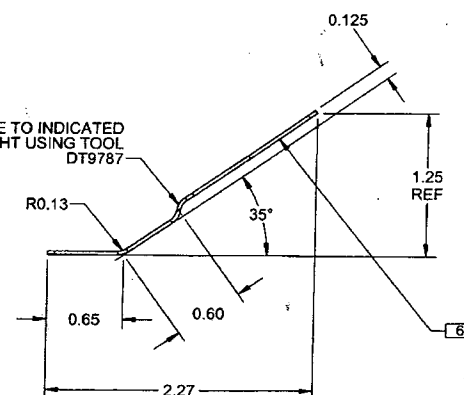


D4594-1 PLATE

NOTES:

- 1) MATERIAL: MAKE FROM D4594-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4594-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

JOGGLE TO INDICATED
HEIGHT USING TOOL
DT9787



RELEASED
2012-02-16

A		NEW ISSUE		CP		12.01.09	
REV.		DESCRIPTION		BY		DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 2	
DRAWN							
CHECKED		DRAWING NO.		D4594		SCALE	
MFG. APPR.		TITLE		PLATE		NTS	
APPROVED		DATE		12.01.09			
DE APPR.							

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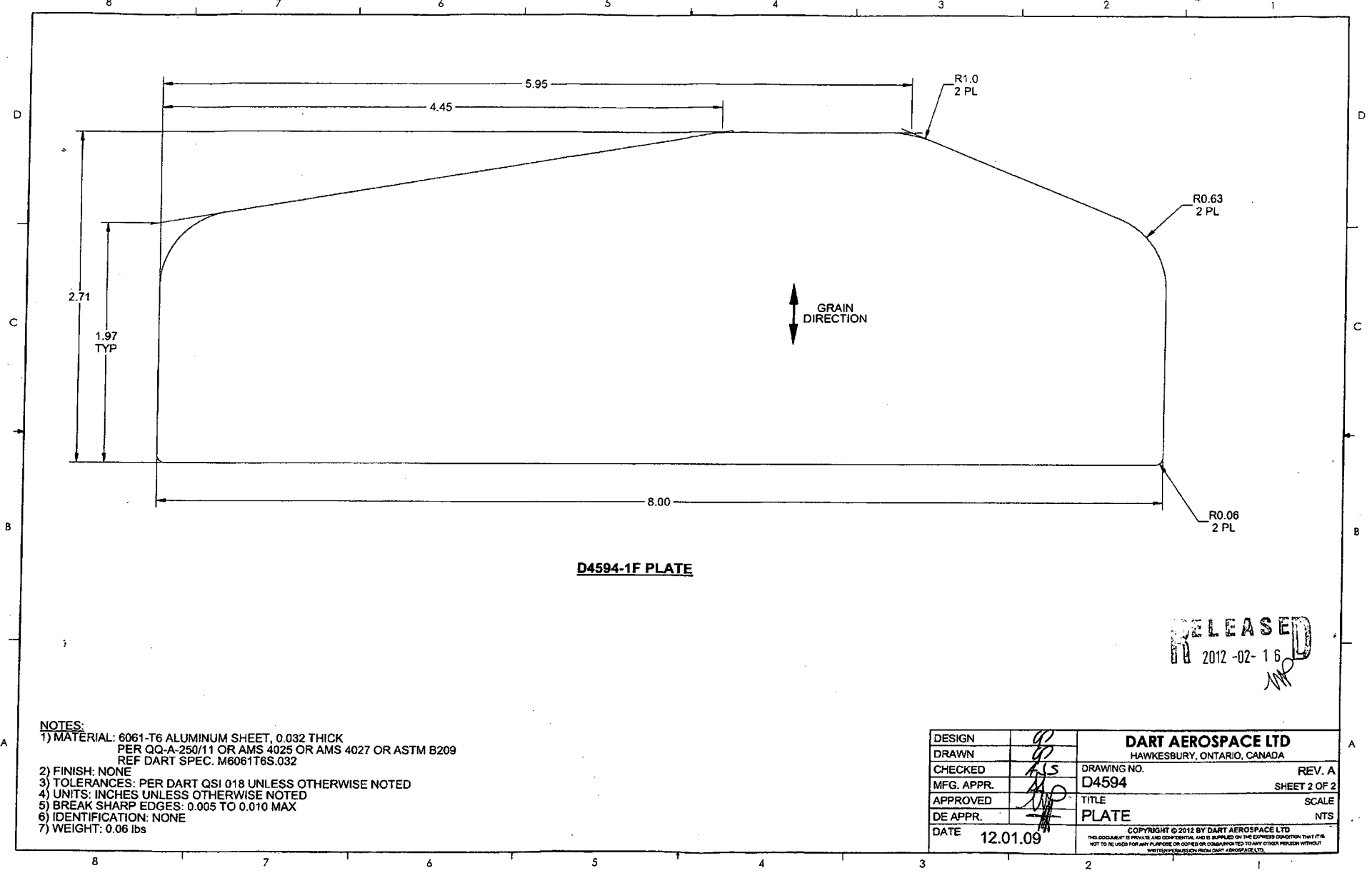
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00506



- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4594	REV. A
MFG. APPR.		TITLE PLATE	SHEET 2 OF 2
APPROVED			SCALE
DE APPR.			NTS
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